

Process Sheet

Form: mroccs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:15:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BLOCK

Job Number: 32569A

Part Number: D3193041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 070907

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS

07-09-11

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/09/13 8

9.0

MS20426AD37

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 MS20426AD3-7

Rivet

M17694

SB 07/09/13 8

10.0

MS21073L4

NUTPLATE



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21073L4

Nut Plate

*M18728

(20)

M102254 (12)

SB 07/09/13 8

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3193-041 as per Dwg D3193

SB 07/09/13 (8)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter
5 07/09/17 (48)

12. A identify and stock.

07/09/18 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:15:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BLOCK

Job Number: 32569A

Part Number: D3193041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

D 07109/19

Job Completion



u 0789-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

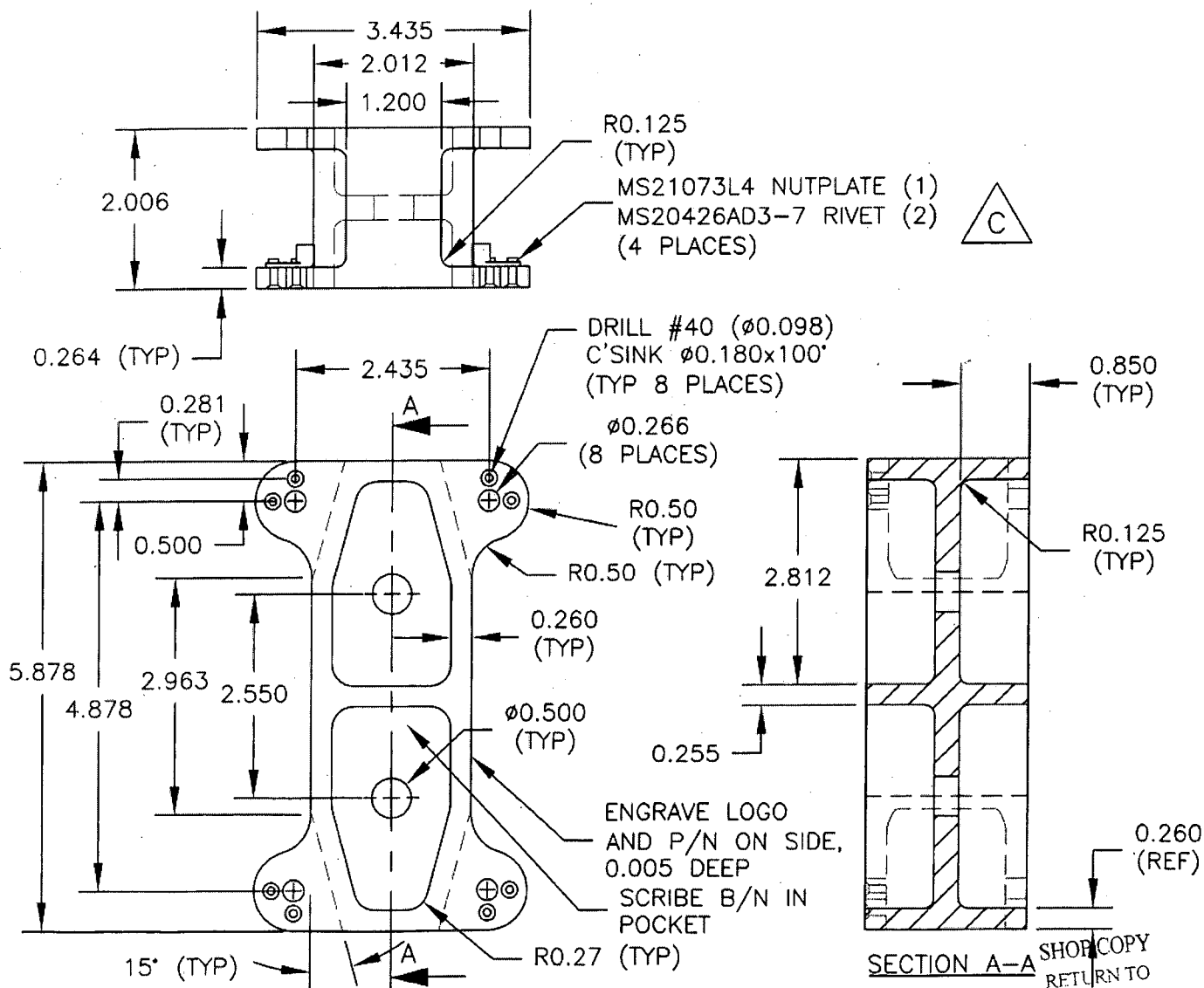
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>TH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>TH</i>	DRAWING NO. D3193	REV. C SHEET 1 OF 1
DATE 05.09.29		TITLE SUPPORT BRACKET ASSEMBLY	SCALE 1:2
A	03.06.09	NEW ISSUE	
B	03.12.22	MANUFACTURED BY DART	
C	05.09.29	MS20426AD3-7 WAS MS20426AD3-5	

RELEASED
05.09.29



D3193-041 SUPPORT BRACKET ASSEMBLY (D3193-1 SUPPORT BRACKET)

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-225/8 OR QQ-A-200/8)
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SECTION A-A
SHORT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32569A

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DART AEROSPACE LTD		Work Order: 32569A
Description: SPACER BLOCK		Part Number: D3193-1
Inspection Dwg: D3193 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.435	$\pm .010$	3.435	—			
2.012	$\pm .010$	2.014	—			
1.200	$\pm .010$	1.200	—			
2.006	$\pm .010$	2.007	—			
R0.125	$\pm .010$	R0.130	—			
0.264	$\pm .010$	0.264	—			
2.435	$\pm .005$	2.435	—			
0.281	$\pm .005$	0.282	—			
0.500	$\pm .010$	0.500	—			
5.878	$\pm .010$	5.879	—			
4.878	$\pm .005$	4.877	—			
15°	$\pm 1/2^\circ$	15°	—			
0.260	$\pm .010$	0.260	—			
R0.50	$\pm .030$	R0.500	—			
Ø0.266	$\pm .006$	Ø0.272	—			
Ø0.098	$\pm .004$	Ø0.101	—			
0.850	$\pm .010$	0.850	—			
R0.125	$\pm .010$	R0.125	—			
2.812	$\pm .010$	2.814	—			
0.255	$\pm .010$	0.255	—			
0.260	$\pm .010$	0.260	—			
Ø0.180X100	$\pm .010$	Ø0.180X100	—			

Measured by: <i>me</i>	Audited by: <i>EG</i>	Prototype Approval: <i>HA</i>
Date: 07/09/03	Date: 07.09.03	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	